

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009238**Date Inspected:** 26-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jha and Xu Yumin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trail Assembly**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) S. Manjunath. Math was present during the times noted above for observations relative to the work being performed.

Orthotropic Box Girder (OBG) Trail Assembly Areas

Segment 1AE to 1AAE

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW). The weld joint is identified as OBE1A-003/002 and 004 at Cross Beam Side. The welder is identified as 045138 and 045196. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-SMAW-1G(1F)-Repair.

Segment 5AE

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Suspender Beam Seal Plate for Suspender Bracket which is installed at Bike Path side at PP 29. The weld joint is performed against Welding Repair Report B-WR2677. The welder is identified as 220066. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-FCAW-3G (3F)-Repair.

Segment 1AW to 1AAW

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This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW). The weld joint is identified as OBW1-001 for segment to segment Transverse weld. The welder is identified as 068764 and 067571. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-SMAW-1G (1F)-Repair-1.

### Segment 2AW

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Mis-drilled hole repair to cable tray bolt hole in T-Stiffener at PP 14 and 15. Welding was performed against Critical Welding Report B-CWR-755 Rev.1. The welder is identified as 220069. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-FCAW-1G(1F)-Repair-Misdrilled hole.

### Segment 5CW

This Quality Assurance (QA) Inspector observed at 5CW at PP36 Counter Weight side Lower Chevron angle connecting to Floor Beam installation was in progress.

### Segment 5CW

This Quality Assurance (QA) Inspector observed at 5CW at PP36 Counter Weight side Lower Chevron East side Shim Plate installation and bolt ASTM A 325 Grade installation was in progress.

### Segment 5CW

This Quality Assurance (QA) Inspector observed at Segment 5CW at PP 35 Cross Beam side Lower Chevron snug tightening was in progress.

### Lift 5 West

This Quality Assurance (QA) Inspector observed for Lift 5 West Suspender Bracket installation area drilling was in progress at Side Panel Counter Weight side.

### Segment 5BW and 5CW

This Quality Assurance (QA) Inspector observed at 5BW and 5CW between PP 34 and 35 Deck Panel Transverse weld temporary cleats flame cut left over been removed by carbon arc gouging.

### Lift 2 East

This Quality Assurance (QA) Inspector observed at Lift 2 East Blasting activity was in progress at internal side of OBG.

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Lift 2 West

This Quality Assurance (QA) Inspector observed at Lift 2 West Blasting activity was in progress at internal side of OBG.

Segment 5AW to 5BW

This Quality Assurance (QA) Inspector observed at Segment 5AW to 5BW Transverse Segment Weld UT scanning being performed by ZPMC QC.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

**Summary of Conversations:**

No relevant conversations.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Math,Manjunath	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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